

GREEN

Dart Aerospace Ltd.

Date: Thursday, 4/26/2007 3:33:56 PM  
 User: Kim Johnston

## Process Sheet

Customer	CU-DAR001 Dart Helicopters Services	Drawing Name	SADDLE FITTING, FWD (OUTBOARD/INBOARD)		
Job Number	32077				
Estimate Number	10531				
P.O. Number	N/A	Part Number	D2572		
This Issue	4/26/2007	S.O. No.	N/A	Drawing Number	D2572 REV E
Prsht Rev.	NC	Type	MACHINED PARTS	Project Number	N/A
First Issue	N/A			Drawing Revision	E
Previous Run	31720			Material	N/A
Written By				Due Date	5/30/2007
Checked & Approved By				Qty:	10
Comment	Est: 102.10.02 Re-format; Change to Dwg Rev. D & incorporated D2572 KJ			Um:	Each

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :		
1.0	D6101005	7075-T7351 8.25X5.0X2.5		
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s) 7075-T7351 8.25X5.0X2.5 Make from D6101-005 billet for D2572 Ensure that grain is along 5.00" length Batch No: B25350		
2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1		
		Comment: HAAS CNC VERTICAL MACHINING #1 Program Batch No. 32076 Double check by: JL		
		1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets 2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets 3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets 4-Deburr and remove all machining marks 5-Tumble to remove sharp edges.		
3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE		
		Comment: CONVENTIONAL MILLING MACHINE Machine keyway as per dwg D2571 & D2572		
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE		
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 07/06/05  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 4/26/2007 3:33:56 PM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE FITTING, FWD (OUTBOARD/INBOARD)

Job Number: 32077

Part Number: D2572

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 QC8

SECOND CHECK



Comment: SECOND CHECK

SA 07.05.30

6.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

AS

07-05-30 10

7.0 POWDER COATING

POWDER COATING



m 104476

Comment: POWDER COATING

— Powder Coat - OLIVE DRAB GREEN  
(Ref: 4.3.5.1) as per QSI 005 4.3

FD

07/06/05 10

8.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

*E. Day 06/05 10*

9.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock  
Location: \_\_\_\_\_

*E. Day 06/05 10*

10.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*A. Day 06/05*

Job Completion



*107-06-05*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD				Work Order:	32077
Description: Saddle, Fwd Inboard				Part Number:	D2572
Inspection Dwg: D2572 Rev. E				Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443	DT8682	0.439	0.439	0.439	0.439		
B	1.745	1.755		1.749	1.749	1.799	1.749		
C	3.495	3.505		3.500	3.499	3.499	3.499		
D	1.745	1.755		1.749	1.749	1.749	1.749		
E	7.990	8.010		8.001	8.000	8.002	8.002		
F	0.490	0.510		0.502	0.503	0.502	0.502		
G	0.257	0.262	DT8683	0.258	0.258	0.258	0.258		
H	0.375	0.380	DT8684	0.376	0.376	0.376	0.376		
I	0.490	0.510		0.503	0.501	0.502	0.502		
J	1.174	1.184		1.177	1.177	1.177	1.177		
K	0.558	0.578		0.573	0.570	0.570	0.570		
L	1.174	1.184		1.177	1.177	1.177	1.177		
M	1.490	1.500		1.493	1.493	1.493	1.494		
N	2.495	2.505		2.499	2.499	2.499	2.500		
O	3.869	3.879		3.871	3.871	3.871	3.871		
P	0.115	0.135		0.126	0.126	0.127	0.126		
Q	0.115	0.135		0.135	0.135	0.135	0.135		
R	0.240	0.260		0.251	0.252	0.252	0.252		
S	0.115	0.135		0.127	0.126	0.125	0.124		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	2.940	2.980		2.960	2.960	2.960	2.960		
V	0.230	0.250		0.240	0.240	0.239	0.241		
W	0.115	0.135		0.126	0.128	0.130	0.129		
X	0.307	0.312		0.311	0.309	0.311	0.310		
Y	0.760	0.765		0.760	0.760	0.760	0.760		
Z	0.352	0.372		0.356	0.359	0.359	0.359		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.632	0.631	0.631	0.632		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.247	0.249	0.248	0.247		
AE	1.375	1.395		1.386	1.387	1.388	1.387		
AF	0.115	0.135		0.135	0.135	0.135	0.135		
AG	0.240	0.280		0.240	0.240	0.245	0.245		
AH	0.240	0.260		0.249	0.248	0.248	0.250		
AI	2.000	2.020		2.000	2.000	2.003	2.002		
AJ	0.023	0.043		0.033	0.033	0.033	0.033		
Accept/Reject									

Measured by:	<i>Cyril</i>	Audited by:	<i>SA</i>
Date:	07/05/28	Date:	07.05.30

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM <i>RF</i> <i>RF</i>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD				Work Order:	32077
Description: Saddle, Fwd Inboard				Part Number:	D2572
Inspection Dwg: D2572 Rev. E				Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443	DT8682	0.439	0.440	0.440	0.440		
B	1.745	1.755		1.749	1.747	1.747	1.746		
C	3.495	3.505		3.499	3.497	3.499	3.498		
D	1.745	1.755		1.749	1.747	1.747	1.746		
E	7.990	8.010		8.002	8.009	8.002	8.000		
F	0.490	0.510		0.502	0.499	0.498	0.496		
G	0.257	0.262	DT8683	0.258	0.258	0.260	0.260		
H	0.375	0.380	DT8684	0.370	0.376	0.377	0.377		
I	0.490	0.510		0.502	0.502	0.498	0.498		
J	1.174	1.184		1.177	1.177	1.178	1.177		
K	0.558	0.578		0.570	0.570	0.565	0.567		
L	1.174	1.184		1.177	1.177	1.178	1.177		
M	1.490	1.500		1.493	1.493	1.493	1.494		
N	2.495	2.505		2.506	2.499	2.498	2.496		
O	3.869	3.879		3.871	3.871	3.872	3.873		
P	0.115	0.135		0.126	0.126	0.127	0.126		
Q	0.115	0.135		0.135	0.135	0.135	0.135		
R	0.240	0.260		0.253	0.253	0.252	0.252		
S	0.115	0.135		0.124	0.124	0.122	0.121		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	2.940	2.980		2.960	2.960	2.960	2.960		
V	0.230	0.250		0.240	0.240	0.237	0.237		
W	0.115	0.135		0.130	0.122	0.124	0.126		
X	0.307	0.312		0.310	0.311	0.311	0.311		
Y	0.760	0.765		0.760	0.765	0.765	0.765		
Z	0.352	0.372		0.358	0.360	0.360	0.366		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.632	0.626	0.625	0.625		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.247	0.247	0.246	0.247		
AE	1.375	1.395		1.388	1.389	1.387	1.386		
AF	0.115	0.135		0.135	0.135	0.135	0.135		
AG	0.240	0.280		0.240	0.246	0.260	0.260		
AH	0.240	0.260		0.249	0.249	0.248	0.246		
AI	2.000	2.020		2.001	2.002	2.000	2.000		
AJ	0.023	0.043		0.033	0.033	0.033	0.033		
Accept/Reject									

Measured by:	Andy Tep	Audited by:	07.08.30
Date:	07/05/29	Date:	5/11

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	2/11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD				Work Order:	32077
Description: Saddle, Fwd Inboard				Part Number:	D2572
Inspection Dwg: D2572 Rev. E				Page 1 of 1	

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D	1.745	1.755		1.748	1.748				
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F	0.490	0.510		0.496	0.494				
G	0.257	0.262	DT8683	0.260	0.260				
H	0.375	0.380	DT8684	0.377	0.377				
I	0.490	0.510		0.499	0.498				
J	1.174	1.184		1.175	1.175				
K	0.558	0.578		0.564	0.567				
L	1.174	1.184		1.175	1.175				
M	1.490	1.500		1.491	1.492				
N	2.495	2.505		2.497	2.497				
O	3.869	3.879		3.872	3.872				
P	0.115	0.135		0.126	0.126				
Q	0.115	0.135		0.135	0.135				
R	0.240	0.260		0.251	0.252				
S	0.115	0.135		0.127	0.120				
T	0.178	0.198		0.188	0.188				
U	2.940	2.980		2.960	2.960				
V	0.230	0.250		0.241	0.241				
W	0.115	0.135		0.128	0.126				
X	0.307	0.312		0.311	0.311				
Y	0.760	0.765		0.765	0.765				
Z	0.352	0.372		0.360	0.362				
AA	0.470	0.530		0.500	0.500				
AB	0.615	0.635		0.625	0.625				
AC	0.053	0.073		0.063	0.063				
AD	0.240	0.260		0.245	0.246				
AE	1.375	1.395		1.388	1.387				
AF	0.115	0.135		0.135	0.135				
AG	0.240	0.280		0.260	0.260				
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AI	2.000	2.020		2.000	2.000				
AJ	0.023	0.043		0.033	0.033				
Accept/Reject									

Measured by: En  
Date: 07/05/10

Audited by: S  
Date: 07.05.10

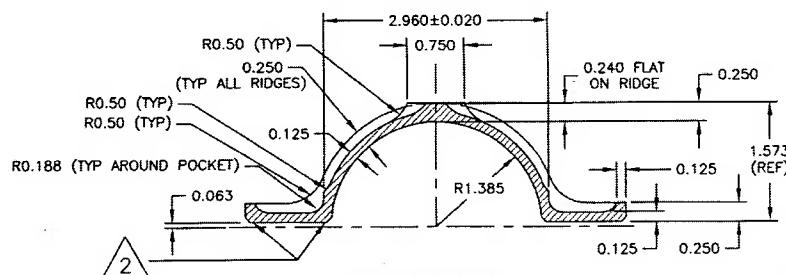
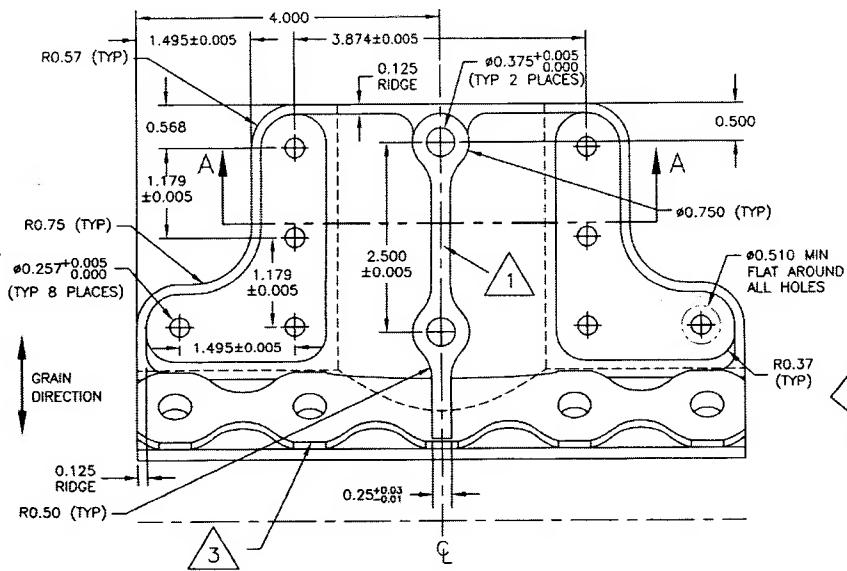
Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	✓ ✓

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

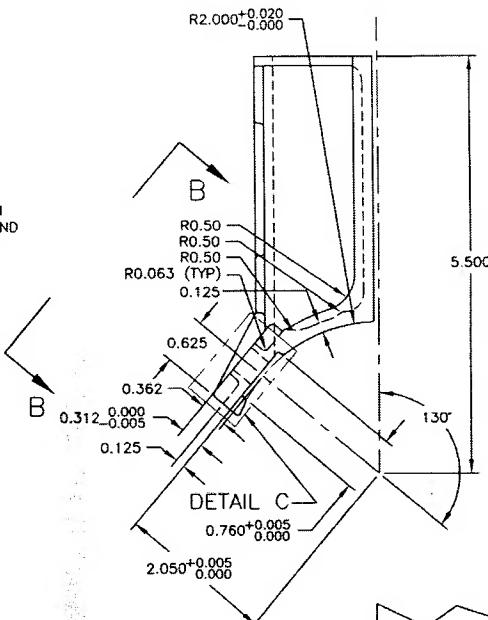
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 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector	
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

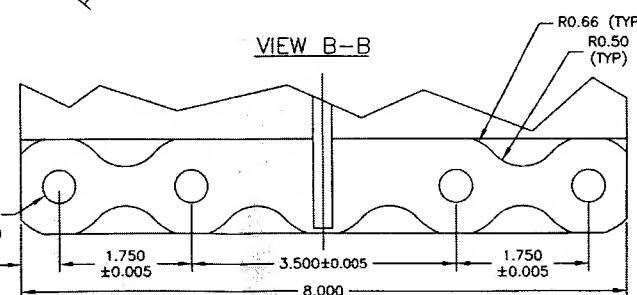
NOTE: Date & initial all entries



SECTION A-A



VIEW B-E



DETAIL C  
SCALE 2:1

SHOP COPY  
RETURN TO  
ENGINEERING  
CONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 33077

05.07.13	ADD CHAMFER ON RIDGE NOTE 4		
02.09.06	ADD RIDGES; TIGHTEN TOLERANCES		
99.10.22	INCORP. DEO 9123/9079/9102 ADD DIMENSIONS PER TSR A1177		
96.12.02	ADD GRAIN DIR., 0.438 WAS 0.425		
96.09.16	NEW ISSUE		
DS	DRAWN BY PH	DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA	
APPROVED		DRAWING NO. D2572	REV. 1 SHEET 1 OF
07.13		TITLE INNER FWD SADDLE	SCAL

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DRAE AEROSPACE LTD.

DART AEROSPACE LTD.

**HAWKESBURY, ONTARIO, CANADA**

BE

ANSWER

SHEET 1

5

DLE

Digitized by srujanika@gmail.com

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector	
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries